

Work Order ID 53005

October 21, 2009 7:57:37 AM



Page 1

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: B/T

Date: 09-10-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3822

C

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

B/B
09/10/27
(X2)
(X1)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA026 using tool DT9074
Dwg Rev: C
Folio Rev: _____

B/B
09/10/27
(X2)
(X1)
P70 →

W/O: 53005		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3822-264 PAR #: N/A Fault Category: Thermal NCR: Yes No DQA: NA Date: 09-11-06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 05-11-17

NCR: 53005		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/28	110.	Buissie (Bump) in Part (Diet) in mold. <u>RC Not correctly cleaned off</u> <u>Since of attention</u> <u>Process lack of attention</u>	<u>esmur</u>	Scrap and Destroy and Replace B# <u>M111807</u>	<u>BB</u> 09/10/29	<u>S</u> 09/10/29	<u>esmur</u>	<u>S</u> 09/10/29

NOTE: Date & initial all entries

Work Order ID 53005

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Page 2

Item ID: D3822-2KGY

Accept

Revision ID: C

Item Name: Vertical Tunnel, RH-Grey

Start Date: 21/10/2009 Start Qty: 2.00

Required Date: 30/10/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/10/27
(X2)
X1 SCAP.

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DL 09/10/27
(X2)

140

Memo

0.00



HandThermo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 09/10/27
(X2)

Work Order ID 53005

October 21, 2009 7:57:37 AM



Page 3

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

BB 09/10/27
X2

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 09/10/29

(X2)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

P 09/10/30 (2)

Work Order ID 53005

October 21, 2009 7:57:37 AM



Page 4

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/30

MF
09-10-30

Picklist Print

October 21, 2009 7:57:43 AM

Page 1

Work Order ID: 53005



Parent Item: D3822-2KGYRevC



Parent Item Name: Vertical Tunnel, RH-Grey

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	702.5028	15.6078			



Kydex steel grey

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111807

702.5028

702.5028

2

09/10/27 BB

DART AEROSPACE LTD		Work Order:	53005
Description: Vertical Tunnel, RH		Part Number:	D3822-2KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/10/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	1.03	✓			
0.3	Min	0.367	✓			
0.55	Min	.781	✓			
0.040	Min	.072	✓			
0.050	Min	.076	✓			

Measured by: BB Date: 09/10/28
Audited by: DL Date: 09/10/28
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>DL</u>	<u>DL</u>

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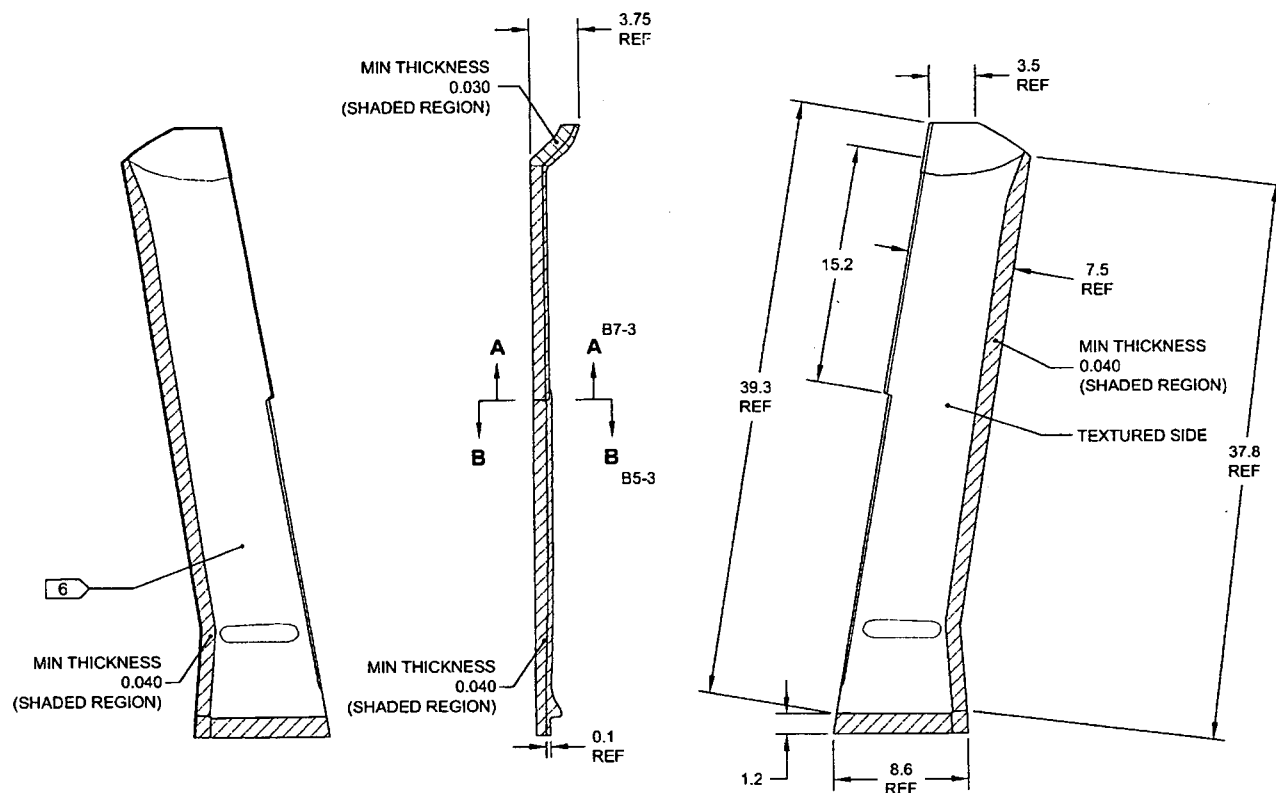
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WITHOUT NOTICE

WORK ORDER

NO. 53005

BT 09-10-21



D3822-1 VERTICAL TUNNEL, LH
(BELL 206 A/B)

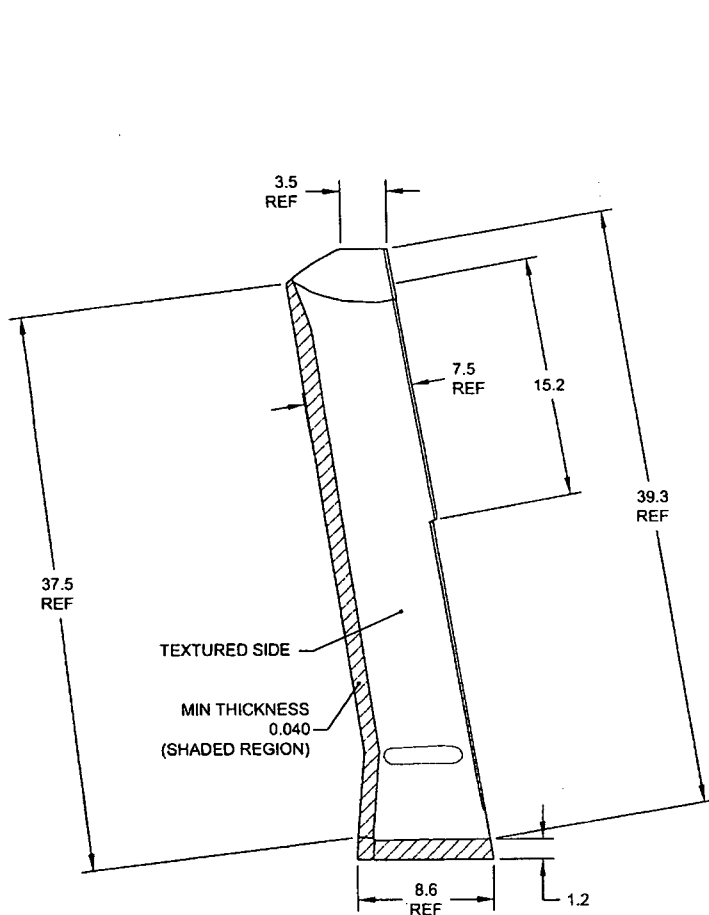
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

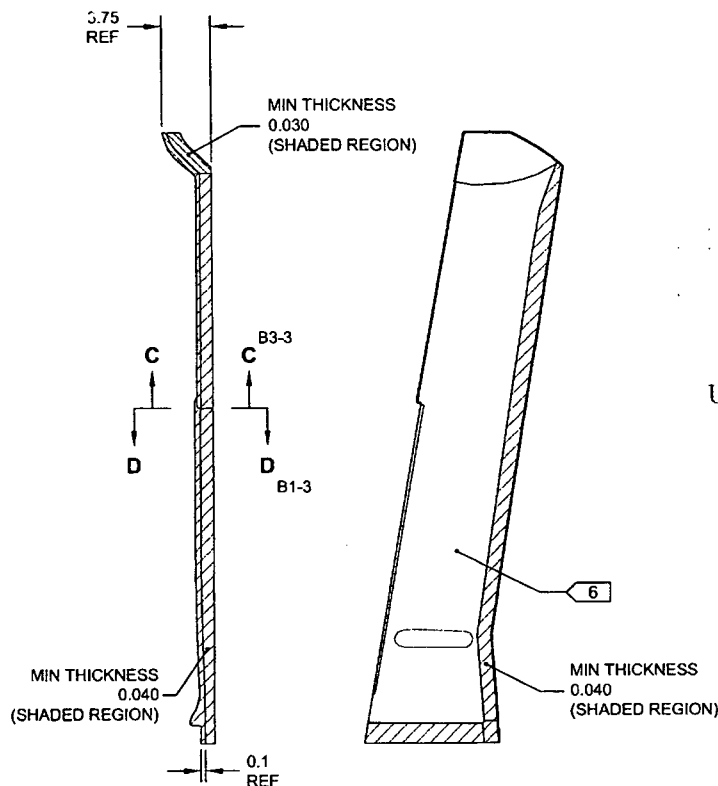


PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1/-2/-3/-5/-7(KIV) AND ADD STEEL GRAY P/N'S D3822-1/-2/-3/-5/-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3822	SHEET 1 OF 6
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)



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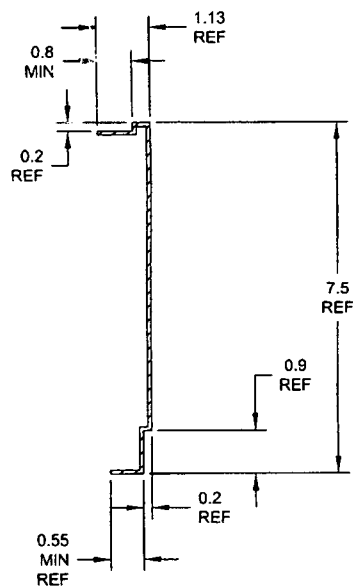
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

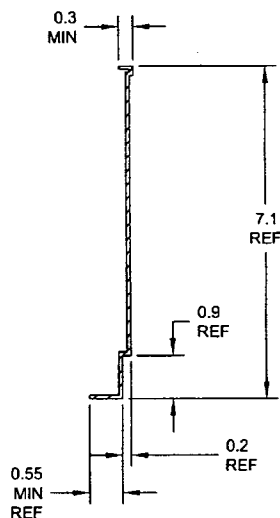


PART NUMBER	DESCRIPTION
D3822-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

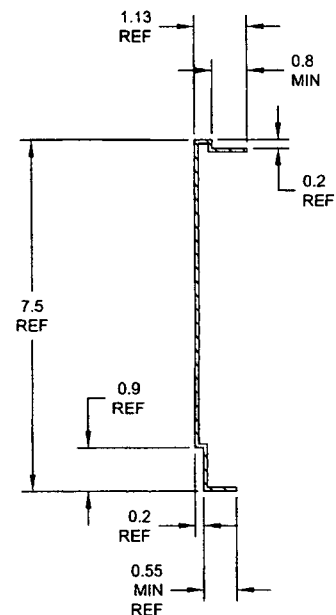
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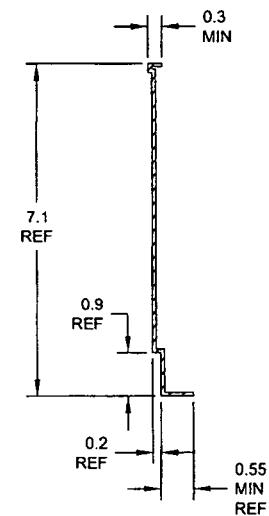
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



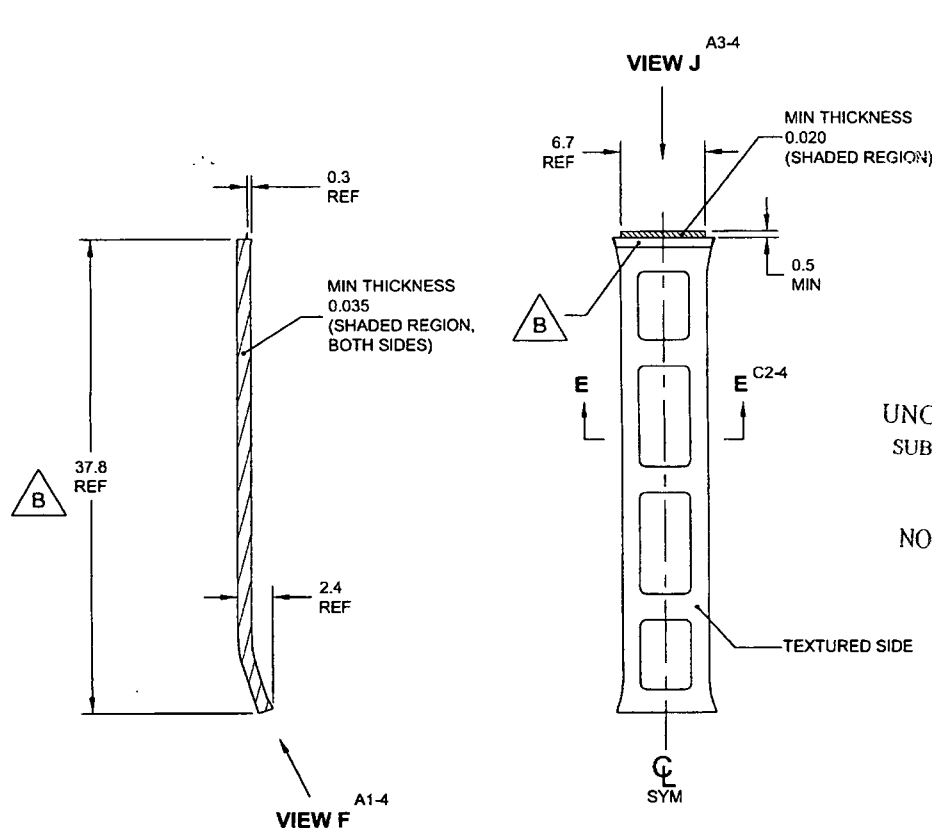
SECTION D-D C4-2

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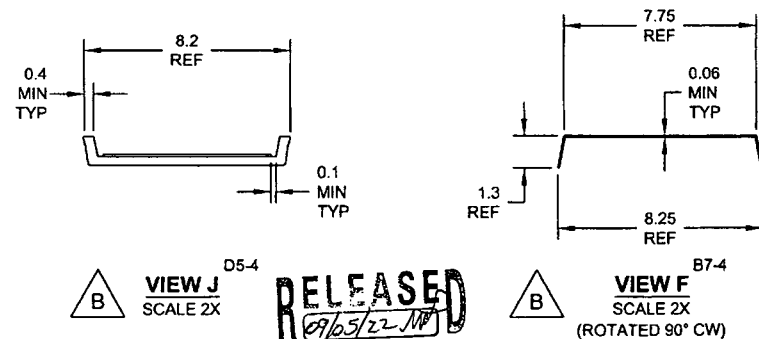
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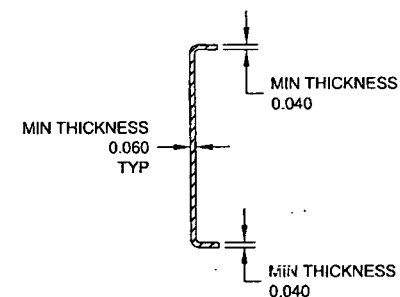
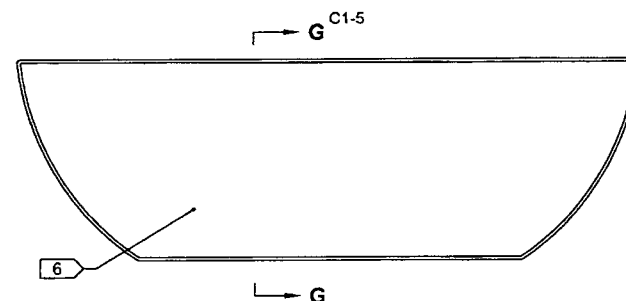
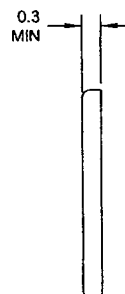
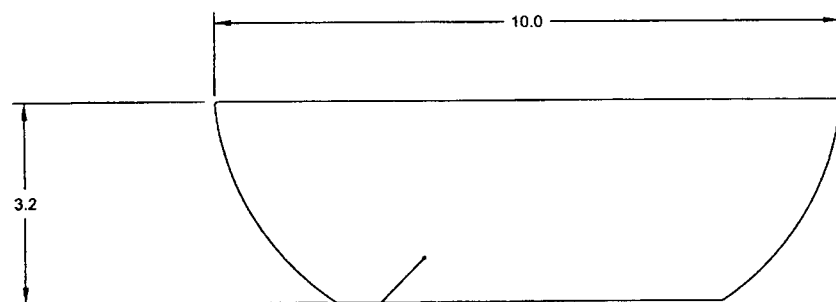
D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
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CHECKED	PA	DRAWING NO. D3822
MFG. APPR.	PA	REV. C
APPROVED	PA	SHEET 4 OF 6
DE APPR.	PA	TITLE SCALE
DATE	09.05.05	VERTICAL TUNNEL (BELL 206 A/B) NTS
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8 7 6 5 4 3 2 1



SECTION G-G C2-5

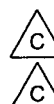
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D3822-5 VERTICAL TUNNEL, TOP
(BELL 206 A/B)

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NOTES:

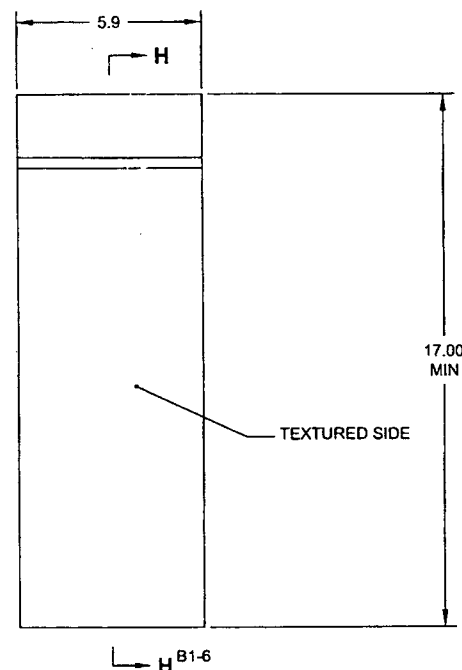
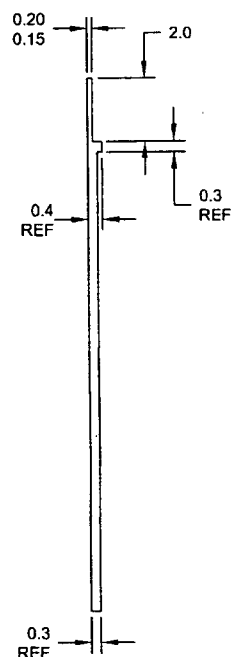
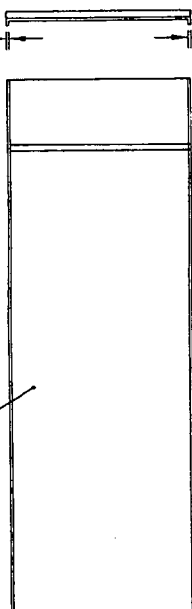
- 1) MATERIAL: SEE TABLE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 6) WEIGHT: 0.12 lbs
- 7) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022



PART NUMBER	DESCRIPTION
D3822-5KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-5KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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MIN THICKNESS 0.040



SECTION H-H B3-6

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

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09/05/22

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	BY	DRAWING NO.	REV. C
MFG. APPR.	BY	D3822	SHEET 6 OF 6
APPROVED	BY	TITLE	SCALE
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